

Date: Monday, 11/08/2008 10:20:26 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SEAT PAN (AFT FACING LH/RH)
Job Number	: 41084		
Estimate Number	: 13362		
P.O. Number	:	Part Number	: D37741
This Issue	: 11/08/2008 S.O. No. :	Drawing Number	: D3774 REV AB
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 11/08/2008 Type : THERMOFORMING	Drawing Revision	: XB <i>ph. 08.08.14</i>
Previous Run	: 40867	Material	:
Written By	:	Due Date	: 28/08/2008 Qty: 10 Um: Each
Checked & Approved By	: <u>JUD 08.8.14</u>		
Comment	: Est. REV:A New Issue 08.06.04 DL verified by:DD		

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

Set up machine program D3774-1

Set up clamping frame as per folio

BB 08/08/14

2.0

MLEXS125F6002904

GE PLASTICS LEXAN SHEET

Comment: Qty: 10.6670 sf(s)/Unit Total : 106.6700 sf(s)

GE PLASTICS LEXAN SHEET

Batch # M105330

BB 08/08/14 X10
BB 08/08/14

3.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Cut Blanks

BB 08/08/14 X10
BB 08/08/14 X10

4.0

THERMOFORMING

THERMOFORMING MACHINE



Comment: THERMOFORMING MACHINE

Thermoform as per Dwg. D3774-1 and Folio

Dwg. Rev. B

Folio Rev. _____

BB 08/08/15 X10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/08/2008 10:20:26 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SEAT PAN (AFT FACING LH/RH)

Job Number: 41084

Part Number: D37741

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

DL 08.08.15 *10

6.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

DL 08.08.27 *10

7.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT TRIMMED PARTS

1) Check dimensions to ensure conformity to drawing tolerances.

DL 08.08.27 *10

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DL 08.08.27 *10

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

248 8/8/29 SP (10x)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/04

Job Completion



MF 08-09-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

#2.

DART AEROSPACE LTD	Work Order: 41084
Description: SEAT PAN (AET FACING)	Part Number: D37741
Inspection Dwg: D3774 Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____"				
Shape Definition	OK		VIS	
Texture Retention	OK		VIS	
Material imperfections such as bumps, cracks, voids, scratching	OK		VIS	

Measured by: WJ

Date: 08.08.26

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.3"	+/- 0.100"	1.36"	✓		Vern	
33.9"	+/- 0.100"	33.875"	✓		TAPE	
17.4"	+/- 0.100"	17.5"	✓		TAPE	
0.085"	MIN	0.092"	✓		Cal	
0.100"	MIN	0.158"	✓		Cal	
0.100"	MIN	0.137"	✓		Cal	
0.100"	MIN	0.161"	✓		Cal	
0.100"	MIN	0.156"	✓		Cal	

Measured by: WJ

Date: 08.08.26

Audited by: [Signature]

Date: 08.08.26

Prototype Approval: [Signature]

Date: _____

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	<u>[Signature]</u>

#3

DART AEROSPACE LTD	Work Order:	41084
Description: SEAT PAN (AET FACING)	Part Number:	D37741
Inspection Dwg: D3774 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____"				
Shape Definition	OK		Vis	
Texture Retention	OK		Vis	
Material imperfections such as bumps, cracks, voids, scratching	OK		Vis	

Measured by: <i>DL</i>	Date: 08.08.26
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TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.3"	+/- 0.100"	1.33"	✓		VERN	
33.9"	+/- 0.100"	33.875"	✓		Tape	
17.4"	+/- 0.100"	17.5"	✓		Tape	
0.085"	MIN	0.088"	✓		Cal	
0.100"	MIN	1.121	✓		Cal	
0.100"	MIN	1.15"	✓		Cal	
0.100"	MIN	1.16"	✓		Cal	
0.100"	MIN	1.30"	✓		Cal	

Measured by: <i>DL</i>	Date: 08.08.26
Audited by: <i>S. 08/08/26</i>	Date: 8/8/28
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	

#4

DART AEROSPACE LTD	Work Order: 41084
Description: SEAT PAN (AET FACING)	Part Number: D37741
Inspection Dwg: D3774 Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____"				
Shape Definition	OK	OK	Vis	
Texture Retention	OK		Vis	
Material imperfections such as bumps, cracks, voids, scratching	OK		Vis	

Measured by: [Signature]	Date: 080826
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TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.3"	+/- 0.100"	1.374"	✓		vern.	
33.9"	+/- 0.100"	33.875"	✓		Tape	
17.4"	+/- 0.100"	17.5"	✓		Tape	
0.085"	MIN	0.092"	✓		Cal	
0.100"	MIN	0.155"	✓		Cal	
0.100"	MIN	0.134"	✓		Cal	
0.100"	MIN	0.130"	✓		Cal	
0.100"	MIN	0.152"	✓		Cal	

Measured by: [Signature]	Date: 080826
Audited by: [Signature]	Date: 8/8/08
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	

#5

DART AEROSPACE LTD	Work Order:	41084
Description: SEAT PAN (AET FACING)	Part Number:	D37741
Inspection Dwg: D3774 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____"				
Shape Definition	✓		Vis	
Texture Retention	✓		Vis	
Material imperfections such as bumps, cracks, voids, scratching	✓		Vis	

Measured by: DL Date: 08.08.96

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.3"	+/- 0.100"	1.317"	✓		Vis.	
33.9"	+/- 0.100"	33.875"	✓		Tape	
17.4"	+/- 0.100"	17.5"	✓		Tape	
0.085"	MIN	0.091"	✓		Cal	
0.100"	MIN	0.115"	✓		Cal	
0.100"	MIN	0.114"	✓		Cal	
0.100"	MIN	0.114"	✓		Cal	
0.100"	MIN	0.122"	✓		Cal	

Measured by: DL Date: 08.08.96
Audited by: DL Date: 08.08.96
Prototype Approval: _____ Date: _____

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	

116

DART AEROSPACE LTD	Work Order: 41084
Description: SEAT PAN (AET FACING)	Part Number: D37741
Inspection Dwg: D3774 Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____"				
Shape Definition	100%		Vis	
Texture Retention	100%		Vis	
Material imperfections such as bumps, cracks, voids, scratching	100%		Vis	

Measured by: [Signature]	Date: 08.08.76
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TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.3"	+/- 0.100"	1.302"	✓		Visual	
33.9"	+/- 0.100"	33.875"	✓		Tape	
17.4"	+/- 0.100"	17.5"	✓		Tape	
0.085"	MIN	0.094"	✓		Cal	
0.100"	MIN	0.143"	✓		Cal	
0.100"	MIN	0.117"	✓		Cal	
0.100"	MIN	0.118"	✓		Cal	
0.100"	MIN	0.140"	✓		Cal	

Measured by: [Signature]	Date: 08.08.76
Audited by: [Signature]	Date: 8/6/80
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	

#7

DART AEROSPACE LTD	Work Order:	41084
Description: SEAT PAN (AET FACING)	Part Number:	D37741
Inspection Dwg: D3774 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____"				
Shape Definition	OK		Vis	
Texture Retention	OK		Vis	
Material imperfections such as bumps, cracks, voids, scratching	OK		Vis	

Measured by: <i>OK</i>	Date: 08.08.26
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TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.3"	+/- 0.100"	1.309"	✓		Veru	
33.9"	+/- 0.100"	33.875"	✓		Tape	
17.4"	+/- 0.100"	17.5"	✓		Tape	
0.085"	MIN	0.092"	✓		Cal	
0.100"	MIN	0.160"	✓		Cal	
0.100"	MIN	0.145"	✓		Cal	
0.100"	MIN	0.140"	✓		Cal	
0.100"	MIN	0.133"	✓		Cal	

Measured by: <i>OK</i>	Date: 08.08.26
Audited by: <i>OK</i>	Date: 8/10/26
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	

#8.

DART AEROSPACE LTD	Work Order: 41084
Description: SEAT PAN (AET FACING)	Part Number: D37741
Inspection Dwg: D3774 Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____"				
Shape Definition	OK		Vis	
Texture Retention	OK		Vis	
Material imperfections such as bumps, cracks, voids, scratching	OK		Vis	

Measured by: JH	Date: 08.08.26
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TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.3"	+/- 0.100"	1.298"	✓		Vern	
33.9"	+/- 0.100"	33.875"	✓		Tape	
17.4"	+/- 0.100"	17.5"	✓		Tape	
0.085"	MIN	0.088"	✓		Cal	
0.100"	MIN	0.131"	✓		Cal	
0.100"	MIN	0.117"	✓		Cal	
0.100"	MIN	0.117"	✓		Cal	
0.100"	MIN	0.130"	✓		Cal	

Measured by: JH	Date: 08.08.26
Audited by: S	Date: 8/8/26
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	

#19

DART AEROSPACE LTD	Work Order:	41084
Description: SEAT PAN (AET FACING)	Part Number:	D37741
Inspection Dwg: D3774 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____"				
Shape Definition	OK		Vis	
Texture Retention	OK		Vis	
Material imperfections such as bumps, cracks, voids, scratching	OK		Vis	

Measured by: OK	Date: 08.08.26
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TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.3"	+/- 0.100"	1.24"	✓			
33.4"	+/- 0.100"	33.875"	✓			
17.4"	+/- 0.100"	17.5"	✓			
0.085"	MIN	0.092"	✓			
0.100"	MIN	0.130"	✓			
0.100"	MIN	0.125"	✓			
0.100"	MIN	0.133"	✓			
0.100"	MIN	0.196"	✓			

Measured by: OK	Date: 08.08.26
Audited by: S	Date: 8/8/26
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	

#10

DART AEROSPACE LTD	Work Order: #1084
Description: SEAT PAN (AET FACING)	Part Number: D37741
Inspection Dwg: D3774 Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____"				
Shape Definition	OK	✓	Vis	
Texture Retention	OK		Vis	
Material imperfections such as bumps, cracks, voids, scratching	OK		Vis	

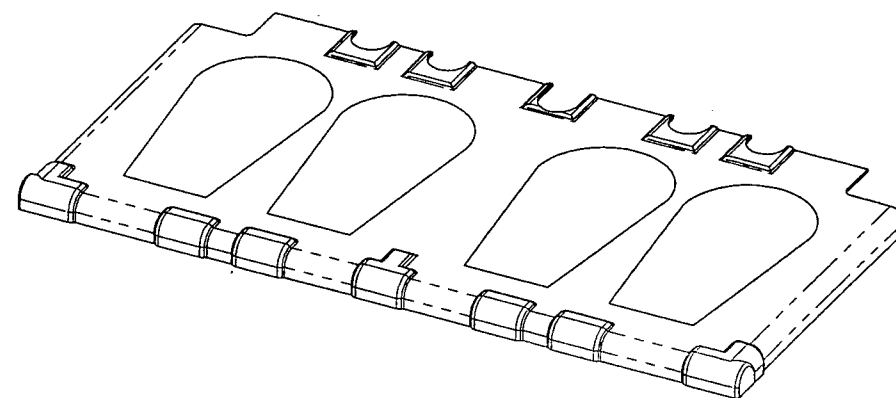
Measured by: <i>OK</i>	Date: 08.08.76
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TRIMMING SECTION

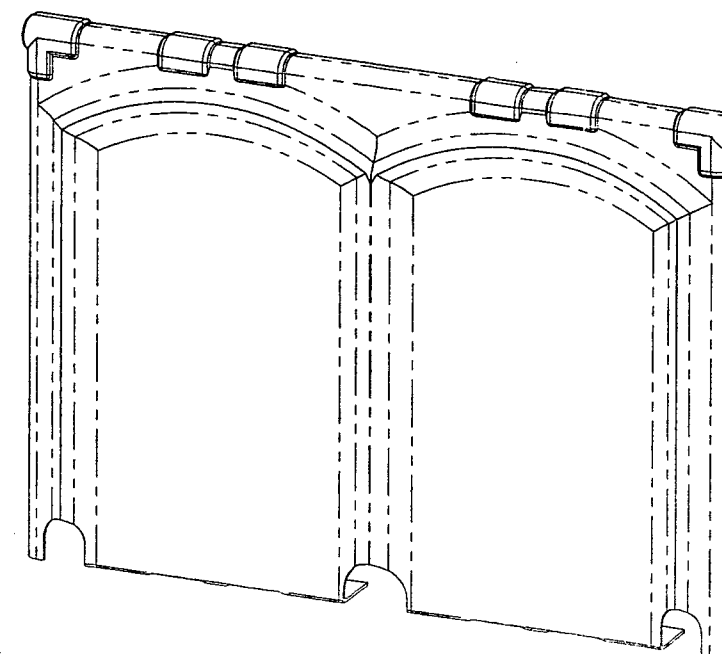
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.3"	+/- 0.100"	1.305"	✓		Visual	
33.9"	+/- 0.100"	33.875"	✓		Tape	
17.4"	+/- 0.100"	17.5"	✓		Tape	
0.085"	MIN	0.087"	✓		Cal	
0.100"	MIN	0.115"	✓		Cal	
0.100"	MIN	0.117"	✓		Cal	
0.100"	MIN	0.118"	✓		Cal	
0.100"	MIN	0.125"	✓		Cal	

Measured by: <i>OK</i>	Date: 08.08.76
Audited by: <i>S</i>	Date: 8/8/76
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	



D3774-1 SEAT BOTTOM

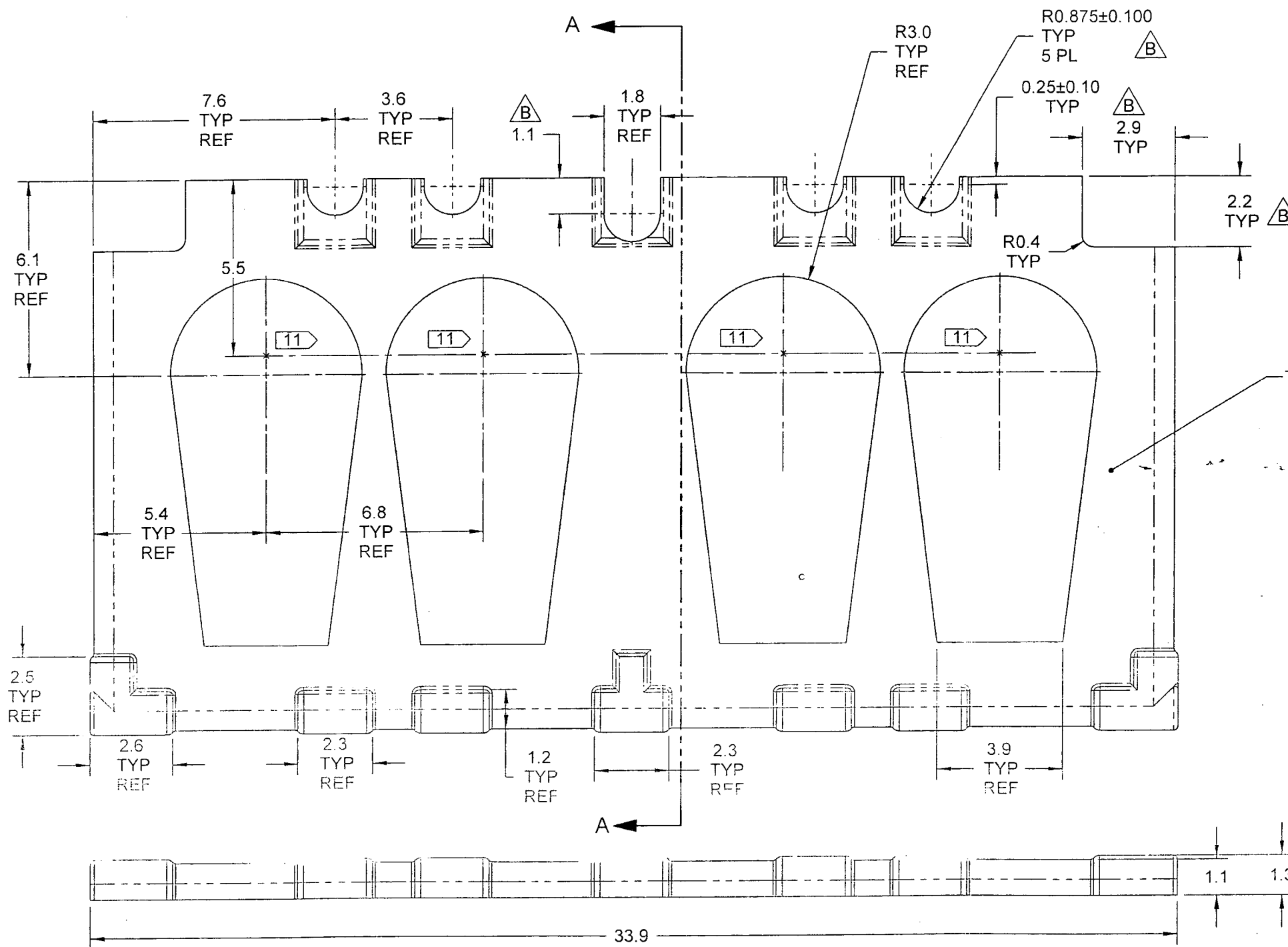


D3774-3 SEAT BACK

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WITHOUT NOTICE
WORK ORDER
NO. 41084

RELEASED
08-08-11/11

B	UPDATE CUTOUT DIMENSIONS (ZN D4-2, D6-2, C4-3, C7-3); UPDATE MINIMUM THICKNESS (ZN A5-2, A5-3); ADD HOLES ON D3774-3 (ZN B6-3) REASON: MANUFACTURING CAPABILITIES	PH	08.07.25
A	NEW ISSUE	HS	08.06.23
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH		
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	PH	D3774	SHEET 1 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	SEAT	NTS
DATE	08.07.25	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



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NO. 4684

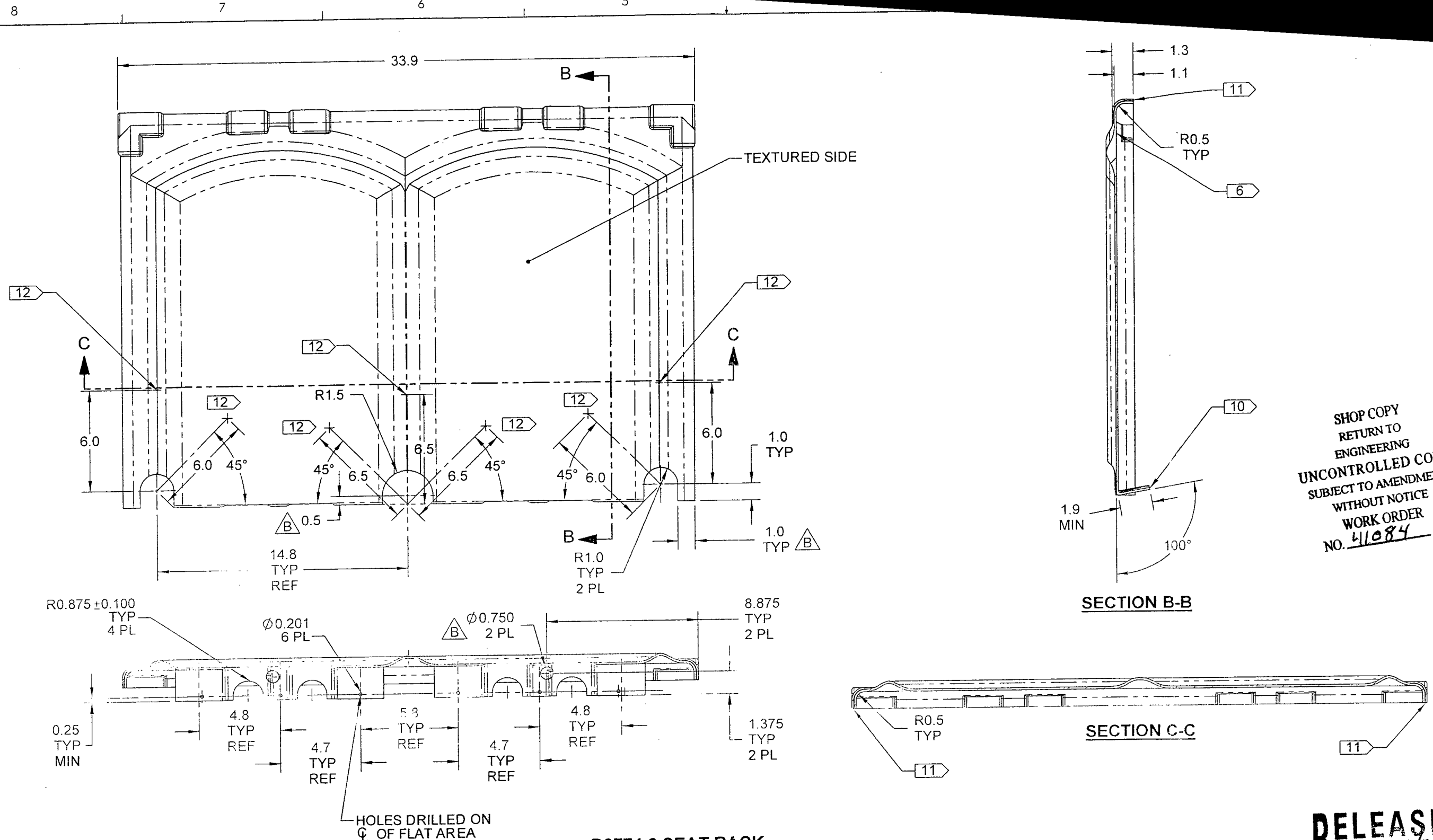
SECTION A-A

D3774-1 SEAT BOTTOM

- NOTES:
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) 0.125" THICK TEXTURED SIDE UP (REF. DART SPEC MLEXS.125-F60029-04)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3774-1" USING VIBRATING STYLUS
 - 7) WEIGHT: 2.93 lbs
 - 8) PART TO BE PRODUCED FROM MOLD DT9022 AND PER DART QSI 022
 - 9) OVERALL DIMENSIONS GIVEN ONLY FOR FURTHER INFORMATION REFER TO MOLD DT9022
 - 10) MINIMUM MATERIAL THICKNESS AFTER FORMING ON FLANGES (WITHIN 2.0 FROM EDGES) IS 0.085
 - 11) MINIMUM MATERIAL THICKNESS AFTER FORMING AT THESE POINTS IS 0.100

RELEASED
08-06-11

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	PA	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3774	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SEAT	NTS
DATE	08.07.25	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



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WITHOUT NOTICE
WORK ORDER
NO. 41084

D3774-3 SEAT BACK

- NOTES:
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) 0.125" THICK TEXTURED SIDE UP (REF. DART SPEC MLEXS.125-F60029-04)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3774-3" USING VIBRATING STYLUS
 - 7) WEIGHT: 4.82 lbs
 - 8) PART TO BE PRODUCED FROM MOLD DT9023 AND PER DART QSI 022
 - 9) OVERALL DIMENSIONS GIVEN ONLY FOR FURTHER INFORMATION REFER TO MOLD DT9023
 - 10) MINIMUM MATERIAL THICKNESS AFTER FORMING ON BOTTOM FLANGE IS 0.065
 - 11) MINIMUM MATERIAL THICKNESS AFTER FORMING FLANGES (WITHIN 2.0 FROM EDGES) IS 0.085
 - 12) MINIMUM MATERIAL THICKNESS AFTER FORMING AT THESE POINTS IS 0.100

RELEASED
08-05-11

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	PA	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SA	DRAWING NO.	REV. B
MFG. APPR.	WJ	D3774	SHEET 3 OF 3
APPROVED	WJ	TITLE	SCALE
DE APPR.	WJ	SEAT	NTS
DATE	08.07.25	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	